



Dart Aerospace Ltd.
1270 Aberdeen St
Hawkesbury, ON
K6A 1K7
Canada

Tel (613) 632-5200
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D3196-1
Job Sheet 201557



Part No: D3196-1

Job Qty: 5 pcs

Part Name: Bar



Part Weight: 0 lbs

Status: New

Priority: Medium

Job Created: 10/7/19

Job Tracking No:

Created By: Marie Lajeunesse

Due Date: 10/25/19

Description:

Type: SOLD

Note: DWG REV C IPP Rev: A New Issue 05-11-08 JLM

Ship Via:

Bill of Materials

Job Routing

Op No	Operation	Qty	Start Date	Due Date	Standard		Workcenter/Supplier		Sign-off
					Setup Hrs	Run Hrs	Workcenter / Supplier	Lead Time	
100	Bandsaw - 1	5 pcs		10/25/19	0.00	0.21	Bandsaw - 1		SBL 19/10/18
110	HAAS 4 Axis - B4B	5 pcs		10/25/19	0.47	4.55	HAAS - 1 - B4B		
							HAAS - 2 - B4B		
							HAAS - 3 - B4B		SBL 19/10/18
							HAAS - 4 - B4B		
120	QC 2	5 pcs		10/25/19	0.00	0.00	QC 2 - 1		
							QC 2 - 12		
							QC 2 - 14		
							QC 2 - 17		
							QC 2 - 19		
							QC 2 - 2		
							QC 2 - 20		
							QC 2 - 22		
							QC 2 - 23		ALS 19/10/19
							QC 2 - 25		
							QC 2 - 32		
							QC 2 - 33		
							QC 2 - 35		
							QC 2 - 39		
							QC 2 - 4		
							QC 2 - 40		
							QC 2 - 44		
							QC 2 - 45		
							QC 2 - 48		
							QC 2 - 49		
							QC 2 - 50		
							QC 2 - 51		
							QC 2 - 52		
							QC 2 - 57		
							QC 2 - 62		



Container No: S223762



Part: D3196-1

Job No: 201557

Serial No/Batch: S223762

Revision:

Inspector:

Exp Date:

Instructions: Various STC's

DART Aerospace Ltd.
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CANADA
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Email: sales@dartaero.com
www.dartaerospace.com

Date: 10/18/19

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130 QC 8	5 pcs	10/25/19	0.00 0.00	QC 2 - 63	
				QC 2 - 8	
				QC 2 - 66	
				QC 2 - 64	
				QC 2 - 65	
				QC 2 - 5	
				QC 2 - 71	
				QC 2 - 73	
				QC 2 - 69	
				QC 8 - 12	
				QC 8 - 14	
				QC 8 - 17	
				QC 8 - 20	
				QC 8 - 25	
				QC 8 - 3	
				QC 8 - 32	
				QC 8 - 33	
				QC 8 - 35	
				QC 8 - 39	
				QC 8 - 4	
				QC 8 - 44	
				QC 8 - 45	
				QC 8 - 49	
				QC 8 - 58	
				QC 8 - 8	
				QC 8 - 9	
				QC 8 - 68	
				QC 8 - 67	
				QC 8 - 1 (A)	
				QC 8 - 47	
				QC 8 - 40	
				QC 8 - 52	
				QC 8 - 23	
				QC 8 - 57	
				QC 8 - 76	
				QC 8 - 61	
140 Handfinish - 1-1 Chemical- B4B	5 pcs	10/25/19	0.00 0.38	Handfinish - 1 - 1 - B4B	
				Handfinish - 1 - 2 - B4B	
				Handfinish - 1 - 3 - B4B	
				Handfinish - 1 - 4 - B4B	
				Handfinish - 1 - 5 - B4B	
				Handfinish - 1 - 6 - B4B	
				Handfinish - 1 - 7 - B4B	
				Handfinish - 1 - 8 - B4B	
				Handfinish - 1 - 9 - B4B	
				Handfinish - 1 - 10 - B4B	
				Handfinish - 1 - 11 - B4B	
				Handfinish - 1 - 12 - B4B	
				Handfinish - 1 - 13 -	

DAS
52
9-89

19/10/23

OCT 24 2019

					B4B	
					Handfinish - 1 - 14 - B4B	
					Handfinish - 1 - 15 - B4B	
					Handfinish - 1 - 16 - B4B	
					Handfinish - 1 - 17 - B4B	
					Handfinish - 1 - 18 - B4B	
					Handfinish - 1 - 19 - B4B	
					Handfinish - 1 - 20 - B4B	
					Handfinish - 1 - 21 - B4B	
					Handfinish - 1 - 22 - B4B	
145	Outsource	5 pcs	10/25/19	0.00 0.00		
150	Powdercoat - 3 Grey Sand - B4B	5 pcs	10/25/19	0.00 0.25	Powdercoat - 1 - B4B	
					Powdercoat - 2 - B4B	
					Powdercoat - 3 - B4B	
					Powdercoat - 4 - B4B	
160	QC 3	5 pcs	10/25/19	0.00 0.00	QC 3 - 10	
					QC 3 - 13	
					QC 3 - 15	
					QC 3 - 17	
					QC 3 - 18	
					QC 3 - 2	
					QC 3 - 28	
					QC 3 - 3	
					QC 3 - 30	
					QC 3 - 34	
					QC 3 - 36	
					QC 3 - 41	
					QC 3 - 51	
					QC 3 - 58	
					QC 3 - 59	
					QC 3 - 68	
					QC 3 - 9	
					QC 3 - 40	
					QC 3 - 19	
					QC 3 - 43	
					QC 3 - 24	
					QC 3 - 61	
					QC 3 - 81	
170	Packaging 3-1 - Stock - B4B	5 pcs	10/25/19	0.00 0.00	Packaging 3 - 1 - B4B	
					Packaging 3 - 2 - B4B	
					Packaging 3 - 3 - B4B	
					Packaging 3 - 4 - B4B	
					Packaging 3 - 5 - B4B	
					Packaging 3 - 6 - B4B	
					Packaging 3 - 7 - B4B	
					Packaging 3 - 8 - B4B	
					Packaging 3 - 9 - B4B	
					Packaging 3 - 10 - B4B	
					Packaging 3 - 11 - B4B	
					Packaging 3 - 12 -	

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					B4B	
					Packaging 3 - 13 - B4B	
					Packaging 3 - 14 - B4B	
					Packaging 3 - 15 - B4B	
					Packaging 3 - 16 - B4B	
					Packaging 3 - 17 - B4B	
					Packaging 3 - 18 - B4B	
					Packaging 3 - 19 - B4B	
					Packaging 3 - 20 - B4B	
					Packaging 3 - 21 - B4B	
					Packaging 3 - 22 - B4B	
					Packaging 3 - 23 - B4B	PC ST 286
					Packaging 3 - 24 - B4B	
					Packaging 3 - 25 - B4B	
					Packaging 3 - 26 - B4B	
180 QC 21 - SA	5	10/25/19	0.00 0.00	QC 21 - SA - 21	PAS	NOV 27 2019
pcs				QC 21 - SA - 70	21	
				QC 21 - SA - 53	53	

Part Op 100 - (Bandsaw) Cut blank: (0.75" x 1.50") x 26.200" long Bar
 Descriptions: 110 - (HAAS CNC Vertical Machine) 1-Machine D3196-1 as per Folio FA339 and Dwg D3196 Identify as D3196-1
 120 - (QC2- Inspect parts off machine FAI/FAIB)
 130 - (QC8- Inspect parts - second check)
 140 - (Chemical Conversion Coat per QSI005 4.1)
 150 - (Grey Sandtex(Ref:4.3.5.6) per QSI005 4.3) START TIME: _____
 160 - (QC3- Inspect Part Finish)
 170 - (Identify as per dwg & Stock Location: _____)
 180 - (QC21- Final Inspection - Work Order Release)

Job BOM

Part / Item	Component Name	Quantity	Operation	Container
M6061T6B0.750X01.500	6061-T6 Bar .750 X 1.50	10.9150 ft (2.183 ea)	100-Bandsaw - 1	M137 980
				S204135

Job Allocations

Operation	Component Part	Required	Inventory	Allocated
100-Bandsaw - 1	M6061T6B0.750X01.500	11	74	0

Part Specifications					
Spec No	Description	Target/Tolerance	Limits	Type	Special Comments
1	Bar	26.094inches ± 0.010	26.104 26.084	26.100	Lape.
2	Bar	4.045inches ± 0.010	4.055 4.035	4.047	
3	Bar	18.003inches ± 0.005	18.008 17.998	18.001	
4	Bar	0.750inches ± 0.005	0.755 0.745	0.749	
5	Bar	1.500inches ± 0.010	1.510 1.490	1.500	
6	Bar	0.344inches $+ 0.006$ $- 0.001$	0.350 0.343	0.349	Diameter
7	Bar	0.660inches $+ 0.008$ $- 0.001$	0.668 0.659	0.665	Diameter
8	Bar	100.000Degrees ± 0.500	100.500 99.500	100.0	
9	Bar	0.060inches ± 0.010	0.070 0.050	0.061	
10	Bar	45.000Degrees ± 0.500	45.500 44.500	45.0	
11	Bar	0.750inches ± 0.010	0.760 0.740	0.748	
12	Bar	0.250inches ± 0.010	0.260 0.240	0.249	
13	Bar	3.495inches ± 0.010	3.505 3.485	3.485	
14	Bar	9.000inches ± 0.010	9.010 8.990	8.996	
15	Bar	16.844inches ± 0.010	16.854 16.834	16.836	
16	Bar	21.498inches ± 0.010	21.508 21.488	21.490	
17	Bar	0.125inches ± 0.010	0.135 0.115	0.125	Radius
18	Bar	1.100inches ± 0.010	1.110 1.090	1.100	
19	Bar	0.125inches ± 0.010	0.135 0.115	0.125	Radius
20	Bar	0.444inches ± 0.010	0.454 0.434	0.443	

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Entered: _____ Date: _____

WORK ORDER NON-CONFORMANCE / ROUTE UPDATE

NCR No. _____

Route update only ☐



Job: _____ Part No. _____		DISPOSITION			DEPARTMENT/PROCESS										
		Rework ☐ Scrap ☐ Use-as-is ☐			Skid-tube ☐ Machining ☐ Large Fab ☐		Cross tube ☐ Small Fab ☐ Finishing ☐		Eng. (Non-AW) ☐ Prod. Eng. Coord. ☐ Rec/Store/Packaging ☐		Engineering ☐ Water Jet ☐ Supplier ☐ Quality ☐				
Date: _____		Sequence #: _____		QTY Affected: _____		MRB (QSI042)									
Description Work Order Deviation				Disposition											
Root Cause Operator ☐ Manufacturing Process ☐ Equip/Tooling ☐ Handling/Preservation ☐ Material ☐ Product Improvement ☐ Process Improvement ☐ Human Factors ☐				FAULT CATEGORY											
				Pressure/Forced ☐ Bending ☐ Crushing ☐ Cracks ☐ Crimp/Kink/Ripple/Wave/Twist ☐ Marks/Chatter ☐ Mislabeled ☐			Contamination ☐ Misaligned/off center ☐ BOM/Route ☐ Broken/Damage/Defect ☐ Incomplete/Unclear Instructions ☐ Drill Holes ☐ Fit/Function ☐			Power Loss/Surge ☐ Folio/Program ☐ Grain Direction ☐ Weld ☐ Wrong Stock Pulled ☐ Out of Sequence ☐ Off-set/Set-up ☐			Positioned Wrong ☐ Outside Tolerance ☐ Drawing ☐ Finish ☐ Part Lost/Missing ☐ Misread ☐		
				Other/Details: _____											
				Completed By _____											
				Lead hand / Supervisor _____											
				QC / QA Coordinator _____											